

Date: Monday, 12/01/2009 2:37:02 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : R44 WEARPLATE
 Job Number : 44660
 Estimate Number : 12651
 P.O. Number :
 This Issue : 12/01/2009 S.O. No. : 3
 Prsht Rev. : NC Part Number : D35651
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3565
 Previous Run : 43980 Project Number : N/A
 Material :
 Due Date : 26/01/2009 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : JUL 09.01.13
 Comment : Est Rev:A New Issue 07-01-16 JLM
 est rev B revB dwg 07.04.18 ec
 Est Rev:C rev.c as per dwg 08-01-14 DD verified by:
 Est Rev: D QC5 added to step 8 08.12.22 KJ Verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 0.1418 sf(s)/Unit Total : 1.7010 sf(s)

304/316 .060 Sheet

Batch: 109057 x8 RB 9-1-30

2.0 WATER JET 108724x FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3565

Dwg Rev: C

Prog Rev: C

RB 9-1-30

13

2-Deburr if necessary

RB 9-1-30

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

09.01.30 13

5.0 D30093 Cup



Comment: Qty.: 3.0000 Each(s)/Unit Total : 36.0000 Each(s)

CUP

Batch: B42376

RB 9-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:37:02 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 WEARPLATE

Job Number: 44660

Part Number: D35651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

X13

1-Weld D3009-3 cups as per dwg D3565

2-Weld hard facing as per Dwg D3565 using DT8991 jig

A/R 2059B Hard Coat rod

Batch: M109893

9-2-11

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pp 09.02.12

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

802/02/12 (43)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109648

START TIME:

10:30

OVEN TEMPERATURE:

320°

FINISH TIME:

11:00

BR 09-02-12

(13)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-12 (X13)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 45773

SS 09/02/12 (13)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/13

Job Completion



MF 09-02-12

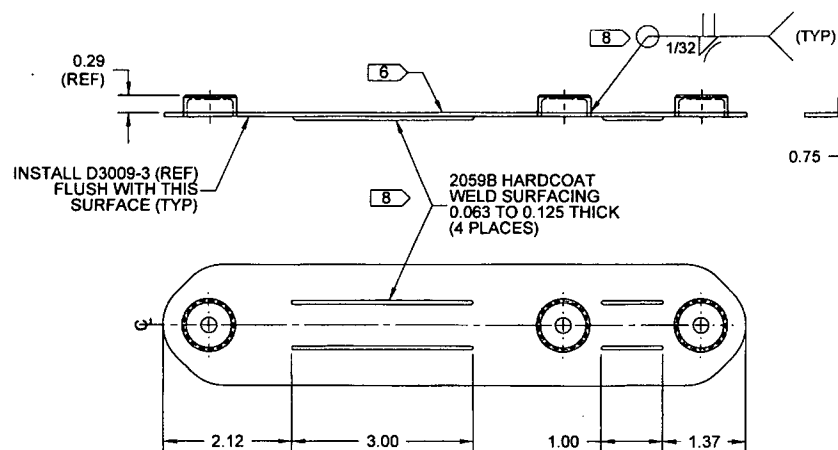
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

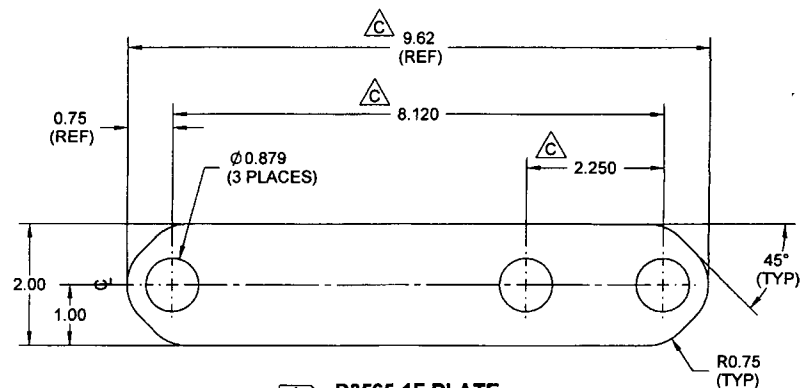
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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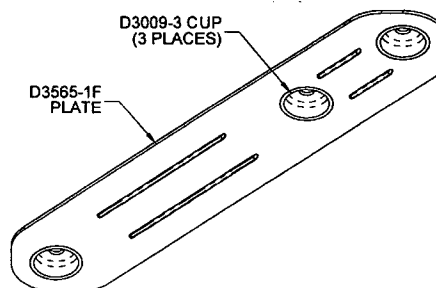
NOTE: Date & initial all entries



D3565-1 R44 WEARPLATE



D3565-1F PLATE



D3565-1 PARTS LIST

| QTY | P/N | DESCRIPTION |
|-----|----------|---------------|
| X | D3565-1 | R44 WEARPLATE |
| 1 | D3565-1F | PLATE |
| 3 | D3009-3 | CUP |

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.38 lbs
- 8) WELD PER DART QSI 004
- 9) PART IS SYMMETRIC ABOUT C

RELEASED
06-01-11

| C | WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220, 2.250 WAS 2.300 (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7) | MB | 07.12.14 |
|--|---|----|----------|
| B | 8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING | CB | 07.03.12 |
| A | NEW ISSUE | CB | 07.01.09 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.12.14 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3565 TITLE R44 WEARPLATE SCALE 1:2 REV. C SHEET 1 OF 1 <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | | | |

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DATE 06-01-11